

Split

Work Order ID 69124-2



Page 1

Tuesday, May 03, 2011 9:53:45 AM

Item ID: D4330-2

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Airframe Bracket

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 1.00



Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan:

MF

Date:

11-05-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4330

PAT PA9

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (made from D4330-1)

Dwg Rev: PA9

Prog Rev: PA9

2-Deburr if necessary

6661 . 063

PB11-5-3



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

PB11-5-3

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

- ins pecked to PAS

Dry only

Sawtooth



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69124

Tuesday, May 03, 2011 9:53:45 AM



Page 2

Item ID: D4330-2

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Airframe Bracket

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

Bend as per dwg
NC BRAKE

Memo

0.00

0.00

SB 1165103

①

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

-inspector to 1169
Dug only
Fullston 116-2

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

EE
1165104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/5/4	130.	send 1 flat pattern to calgary. as well	CHF	11/5/4	1	11.05.04 GSI OKZ.	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/4	130	Sylvie had cut extra pieces because Eric C. told her we needed more. Finally	}	Scrap - Destroy SPUT W/O. IF IN TWO WEEK NO WORD FROM	Sh 11/05/4	}		
		It is OK to send 1 piece finished and 1 flat. pattern out to Eagle		11/05/4 GSI OKZ	EAGLE, SCRAP PARTS.			11/05/4

NOTE: Date & initial all entries

Work Order ID 69124

Tuesday, May 03, 2011 9:53:45 AM



Item ID: D4330-2

Accept



Setup Start



Revision ID: PRELIM

Item Name: Airframe Bracket

Stop



Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

155



Powdercoat

Powder Coating

White Gloss (Ref: 4.3.5.1) per QSI005.4.3-Alum

0.00

Memo

0.00

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

11.05.04

160



QC

Quality Control

QC3-Inspect Part Finish

0.00

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69124

Tuesday, May 03, 2011 9:53:45 AM



Page 4

Item ID: D4330-2

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Airframe Bracket

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

ME
11-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 9:53:42 AM

Page 1

Work Order ID: 69124



Parent Item: D4330-2



Parent Item Name: Airframe Bracket


Start Date: 5/3/2011

Required Date: 5/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.17 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	372.0000	0.265	0.278947			



B1-5-3

Location

Loc Qty

Loc Code

MAT021

372

116308

36

117285

336

116308

~~117285~~



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 69124
Description: AIR FRAME	Part Number: D4330-2
Inspection Dwg: D4330-2, Rev: R49	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

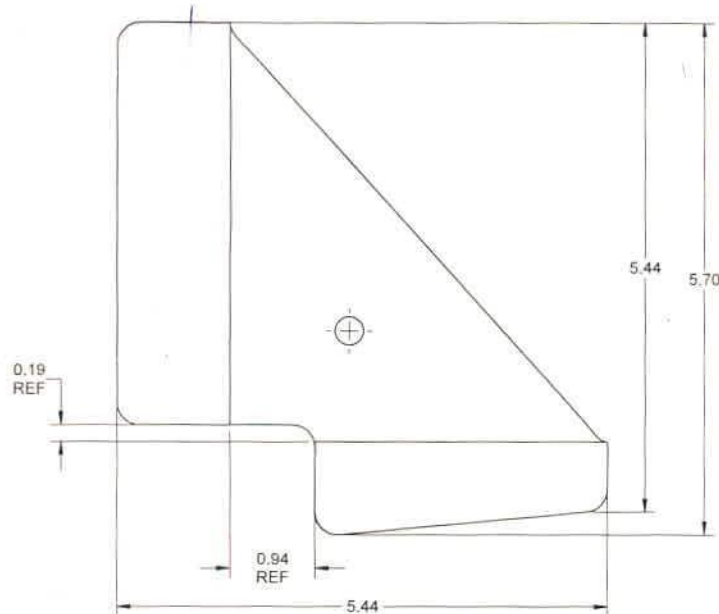
X

X

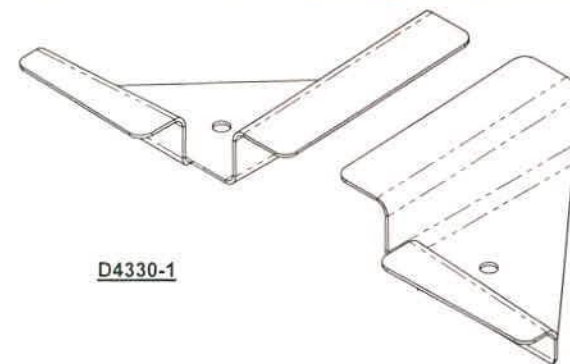
[illegible]

Measured by: HB	Audited by: S	Prototype Approval:
Date: 11-5-14	Date: 11/01/13	Date:
<i>measured to Part Day only</i>		

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



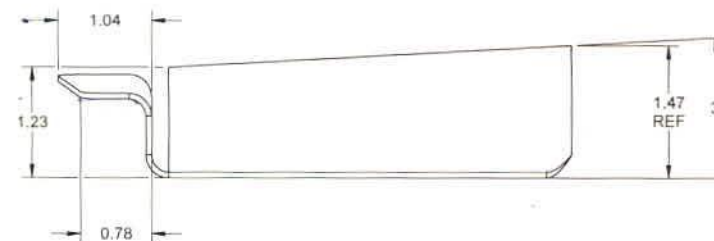
D4330-2 AIRFRAME BRACKET, RH
D4330-1 AIRFRAME BRACKET, LH (OPPOSITE)



D4330-1

D4330-2

#69124



NOTES:

- 1) MATERIAL: MADE FROM D4330-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>JS</i>			
CHECKED	<i>JS</i>		DRAWING NO.	REV. PAS
MFG. APPR.			D4330	SHEET 2 OF 5
APPROVED			TITLE	SCALE
DE APPR.			BRACKET	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

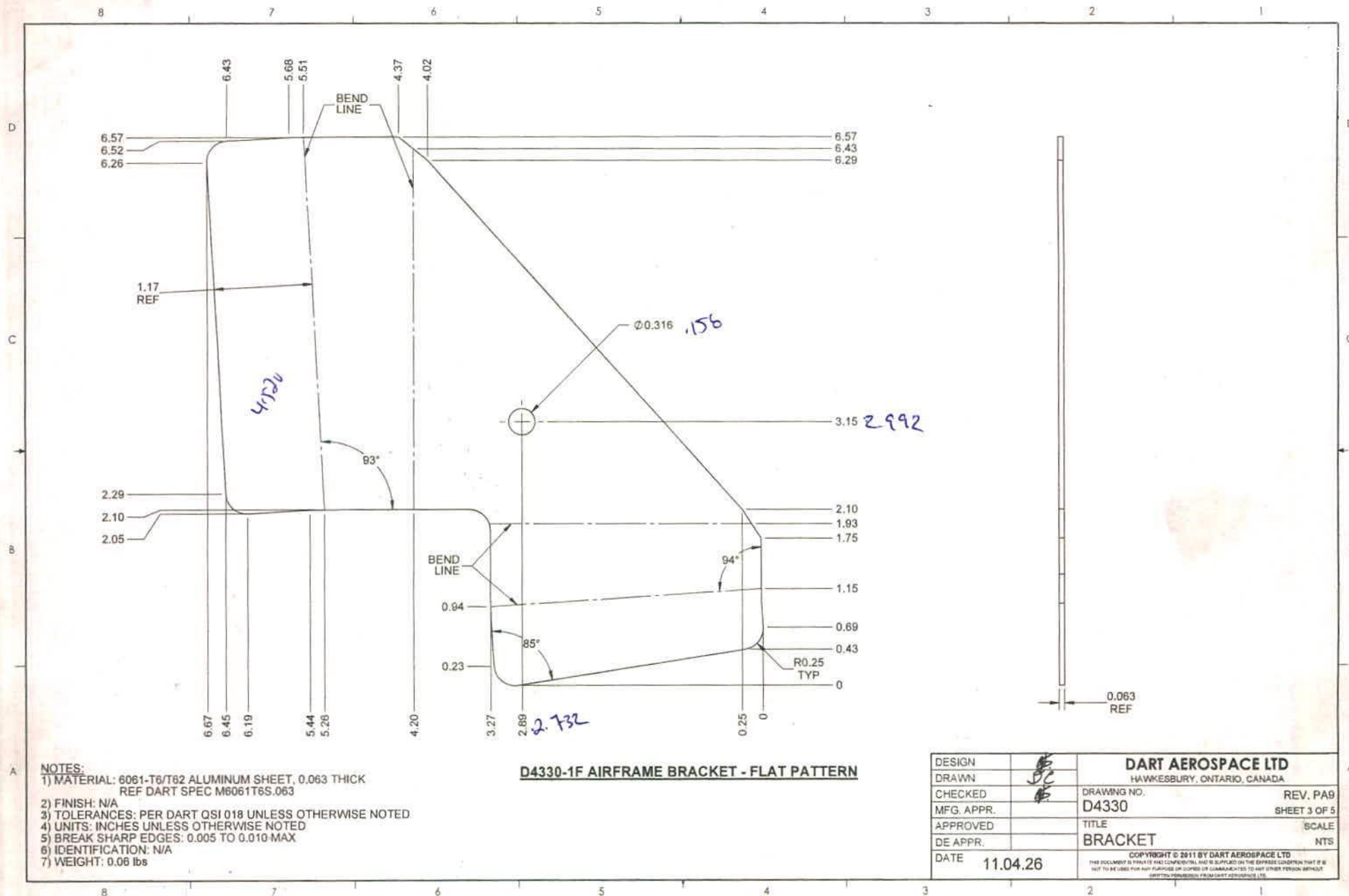
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

D4330-1F AIRFRAME BRACKET - FLAT PATTERN

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PAGE
MFG. APPR.		D4330	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	